



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D3646-3
Job Sheet 176112



Part No: D3646-3

Job Qty: 8 ea

Part Name: Arm



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 4/17/18

Job Tracking No:

Due Date: 5/14/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV C IPP Rev. A new issue 07.07.25 EC verified by:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	8 Ea		5/11/18	0.00	0.00	Start Up Small Fab-4		FF
100	Brake NC	8 pcs		5/12/18	0.00	3.62	Brake NC 1		FF
110	Small Fab	8 pcs		5/12/18	0.00	4.94	Small Fab-4		DAS FF
120	QC	8 pcs		5/12/18	0.00	0.00	QC5		38
130	Powdercoat	8 pcs		5/14/18	0.00	0.26	Powdercoat4		DATE: 5-9
140	QC	8 pcs		5/14/18	0.00	0.00	QC3		MAY 10 2018
150	Packaging	8 pcs		5/14/18	0.00	0.00	Packaging3-1	57377	8-88
160	QC21-SA	8 Ea		5/14/18	0.00	0.00	QC21		MAY 10 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M304TR0.500W.035	304 Round Tube .500 X .035W	23.2800 ft (2.91 ea)	90-Start up Operation	5034343 (1a) 5060102 (2a)

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M304TR0.500W.035	23	143	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Arm	26.500Inches ± 0.130	26.630 26.370		
2	Arm	2.500Inches ± 0.130	2.630 2.370		
3	Arm	5.750Inches ± 0.130	5.880 5.620		
4	Arm	15.000Degrees ± 0.500	15.500 14.500		
5	Arm	45.000Degrees ± 0.500	45.500 44.500		
6	Arm	30.000Degrees ± 0.500	30.500 29.500		

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISI Suspected		AGAINST DEPARTMENT/PROCESS Part: D3646-3 Job No: 176112 Serial No/Batch: S064576 Revision: _____ Inspector: _____ Container No: S064576 DART Aerospace 1270 Aberdeen Street Hawkesbury, ON K6A 1K7 CANADA TEL.: 1 813 832-5200 Email: sales@dartaero.com www.dartaerospace.com Engineering ☐ Quality ☐ Other ☐ 42) Approval ☐ Deleted By _____ _____ / Supervisor Verification A Coordinator approval							
Date : _____ Step #: _____ Description Work Order Deviation											
Root Cause <table style="width: 100%; border-collapse: collapse;"> <tr> <td style="width: 50%; vertical-align: top;"> Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ </td> <td style="width: 50%; vertical-align: top;"> No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐ </td> </tr> </table>		Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	FAULT CATEGORY <table style="width: 100%; border-collapse: collapse;"> <tr> <td style="width: 33%; vertical-align: top;"> Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ </td> <td style="width: 33%; vertical-align: top;"> Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ </td> <td style="width: 33%; vertical-align: top;"> Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ </td> <td style="width: 33%; vertical-align: top;"> Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐ </td> </tr> </table>				Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
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